



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Avic

D2734
Job Sheet 175669



Part No: D2734

Job Qty: 60 ea

Part Name: Step End Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/10/18

Job Tracking No:

Due Date: 7/4/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP: D 01.06.08 Removed Deburr EC IPP Rev:E 07-12-18 RevC as per dwg ECN1048 DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	60 Ea	7/3/18	7/3/18	0.00	0.00	Start Up Waterjet		pc 18/06/02
100	Waterjet	60 pcs	7/3/18	7/3/18	0.00	0.84	Waterjet1		pc 18/06/02
120	QC	60 pcs	7/3/18	7/3/18	0.00	0.00	QC8		SB
130	Small Fab	60 pcs	7/4/18	7/4/18	0.01	0.61	Small Fab-2		SB
140	QC	60 pcs	7/4/18	7/4/18	0.00	0.00	QC5		11/2018-06-12
150	Packaging	60 pcs	7/4/18	7/4/18	0.00	0.00	Packaging3		24/2018-06-12
160	QC21-SA	60 Ea	7/4/18	7/4/18	0.00	0.00	QC21		9-88

Part Op 100 - 1-Cut as per Dwg D 2734

Descriptions: 130 - Form as per drawing D2734

150 - *** STOCK IN STEP CELL***

JUN 17 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M5052H32S.063	5052-H32 .063 Sheet	3.7500 sf (.0625 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M5052H32S.063	4	31	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	End Plate	2.900inches $\pm$ 0.030	2.930 2.870		
2	End Plate	3.040inches $\pm$ 0.030	3.070 3.010		
3	End Plate	0.063inches $\pm$ 0.010	0.073 0.053		

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																				
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval _____																																				
Description Work Order De Dart Aerospace Ltd. 1270 Aberdeen Street Newbury, ON K64 1K7 CANADA TEL.: 613 832-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S077383 Part: D2734 Job No: 175669 Serial No/Batch: S077383 Revision: Inspector: Exp Date: 06/02/2018 Instructions: Date: 06/02/18																																								
Root Cause <table style="width:100%; border: none;"> <tr> <td style="border: none;">Environment ☐</td> <td style="border: none;">No Re-verification ☐</td> <td style="border: none;">Pres ☐</td> </tr> <tr> <td style="border: none;">Design ☐</td> <td style="border: none;">Operator ☐</td> <td style="border: none;">Benc ☐</td> </tr> <tr> <td style="border: none;">Doc/Data ☐</td> <td style="border: none;">Offset/Setup ☐</td> <td style="border: none;">Cent ☐</td> </tr> <tr> <td style="border: none;">Equip/Tooling ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;">Crac ☐</td> </tr> <tr> <td style="border: none;">Handling/Pre ☐</td> <td style="border: none;">Training ☐</td> <td style="border: none;">Crimp/kink/kippie/wave ☐</td> </tr> <tr> <td style="border: none;">Material ☐</td> <td style="border: none;">Use for Testing ☐</td> <td style="border: none;">Cuffs ☐</td> </tr> <tr> <td style="border: none;">Internal Transport ☐</td> <td style="border: none;">Poor Information ☐</td> <td style="border: none;">Crushing ☐</td> </tr> <tr> <td style="border: none;">Tribal Knowledge ☐</td> <td style="border: none;">Rushing ☐</td> <td style="border: none;">Heat Treat ☐</td> </tr> <tr> <td style="border: none;">LOA ☐</td> <td style="border: none;">Product Improvement ☐</td> <td style="border: none;">Wave/Twist in Tube ☐</td> </tr> <tr> <td style="border: none;">Substation ☐</td> <td style="border: none;">Process Improvement ☐</td> <td style="border: none;">Marks/Chatter ☐</td> </tr> <tr> <td style="border: none;">Past Expiry Date ☐</td> <td style="border: none;">Manufacturing Process ☐</td> <td></td> </tr> <tr> <td style="border: none;">Misidentified ☐</td> <td style="border: none;">Past Due ☐</td> <td style="border: none;">OTHER : ☐</td> </tr> </table>				Environment ☐	No Re-verification ☐	Pres ☐	Design ☐	Operator ☐	Benc ☐	Doc/Data ☐	Offset/Setup ☐	Cent ☐	Equip/Tooling ☐	Supplier ☐	Crac ☐	Handling/Pre ☐	Training ☐	Crimp/kink/kippie/wave ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Past Expiry Date ☐	Manufacturing Process ☐		Misidentified ☐	Past Due ☐	OTHER : ☐	Completed By _____ Lead hand / Supervisor _____ Approval Verification _____ QC / QA Coordinator _____ Approval _____ Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence
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